

18 MARS

Work Order ID 81546

81546

Page 1

March-15-12 10:32:12 AM

Item ID: D205-706-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fuel Purge Canister

Start Date: 15/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/15 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D412-706

Rev A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D205-706-013 CHG002

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81546***81546***

Page 2

March-15-12 10:32:12 AM

Item ID: D205-706-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fuel Purge Canister

Start Date: 15/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPPD205-706-013

Location: 22PPP Rev: D

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-15-12 10:32:15 AM

Page 1

Work Order ID: 81546

81546

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 15/03/2012

Required Date: 29/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D
KJ/JLM IPP Rev:F 10.05.10 as per
chg002 DD verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-5A

Purchased

No

110

Each

1,172.000

4

4

AN3-5A

Bolt

** 3x 121185 JB

Location

Loc Qty

Loc Code

ST350

1172

115371

46

117423

204

118626

222

119355

200

120187

500

1x 118626

AN814-6D

Purchased

No

110

Each

7.0000

1

1

AN814-6D

Plug

**

JB

Location

Loc Qty

Loc Code

ST324

7

117946

7

AN815-6D

Purchased

No

110

Each

26.0000

2

2

AN815-6D

Union-M-Flare

**

JB

12/04/13

Location

Loc Qty

Loc Code

ST325

26

119396

6

119433

2

119438

18

119438

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-15-12 10:32:15 AM

Page 2

Work Order ID: 81546

Parent Item: D205-706-013

Parent Item Name: Fuel Purge Canister

81546

D205-706-013

Start Date: 15/03/2012

Required Date: 29/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN833-6D Purchased No

110 Each 11.0000 3 3 ✓

AN833-6D

Elbow, Bulkhead-M-Flare

**

JB

LocationLoc QtyLoc Code

ST327 5

120820 5

ST328 6

118840 1

119546 5

2x 120820

1x 119546

AN924-6D Purchased No

110 Each 28.0000 4 4 ✓

AN924-6D

Nut

**

JB

LocationLoc QtyLoc Code

ST329 28

120521 8

120693 20

120693

AN960JD10 NAS1149D0363J Purchased No

110 Each 0.0000 8 8 ✓

AN960.ID10

Washer

**

121243 JB

AN960JD10L NAS1149D0332J Purchased No

110 Each 0.0000 4 4 ✓

*AN960.ID10I *

Washer

**

120644 JB

AN960JD916 NAS1149D0963J Purchased No

110 Each 0.0000 2 2 ✓

AN960.ID916

WASHER

**

118078 JB 12/04/13

March-15-12 10:32:16 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-15-12 10:32:16 AM

Page 3

Work Order ID: 81546

81546

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 15/03/2012

Required Date: 29/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2001-4 Manufactured No

110 Each 16.0000 1 1 ✓

D2001-4

Valve Assembly (1/4")

**

Location

Loc Qty

Loc Code

ST002

16

77058

6

77201

10

77058

D3262-041 Manufactured No

110 Each 0.0000 1 1 ✓

D3262-041

Canister Assembly

**

79825

D3264-1

Manufactured No

110 Each 2.0000 2 2 ✓

D3264-1

Bracket

**

Location

Loc Qty

Loc Code

ST198A

2

75995

2

75995

D3297-1-0121 Manufactured No

110 Each 4.0000 1 1 ✓

D3297-1-0121

HOSE ASS'Y

**

Location

Loc Qty

Loc Code

ST191

4

76200

4

76200

D3297-1-0130 Manufactured No

110 Each 5.0000 1 1 ✓

D3297-1-0130

HOSE ASS'Y

**

Location

Loc Qty

Loc Code

ST191

5

55069

1

76202

4

76202

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-15-12 10:32:16 AM

Page 4

Work Order ID: 81546

81546

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 15/03/2012

Required Date: 29/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3297-3-0350

Manufactured No

110 Each

3.0000

1 1 2
**

D3297-3-0350

HOSE ASS'Y

Location

Loc Qty

Loc Code

ST192

3

47420

1

58005

2

58005

D3298-001

Manufactured No

110 Each

10.0000

1 1 ✓
**

D3298-001

Tube Assembly

Location

Loc Qty

Loc Code

ST192

10

47421

4

48507

6

47421

D3298-009

Manufactured No

110 Each

4.0000

1 1 ✓
**

D3298-009

Tube Assembly

Location

Loc Qty

Loc Code

ST192

4

47506

4

47506

D3299-1

Manufactured No

110 Each

8.0000

1 1 ✓
**

D3299-1

Fitting

Location

Loc Qty

Loc Code

ST037

8

42170

8

42170

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-15-12 10:32:16 AM

Page 5

Work Order ID: 81546

81546

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 15/03/2012

Required Date: 29/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3299-3 Manufactured No

110

Each

6.0000

1

1

**

D3299-3

Fitting

LocationLoc QtyLoc Code

ST037

6

75978

6

75978

D3301-1 Manufactured No

110

Each

7.0000

1

1

**

D3301-1

Placard

LocationLoc QtyLoc Code

ST037

7

73092

1

77598

6

77598

D3301-3 Manufactured No

110

Each

19.0000

1

1

**

D3301-3

Placard

LocationLoc QtyLoc Code

ST037

19

77203

9

77856

10

77203

D3302-1 Manufactured No

110

Each

4.0000

1

1

**

D3302-1

Doubler

LocationLoc QtyLoc Code

ST198

4

73094

4

73094

March-15-12 10:32:16 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-15-12 10:32:16 AM

Page 6

Work Order ID: 81546

81546

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 15/03/2012

Required Date: 29/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3302-3

Manufactured No

110 Each

2.0000

1 1 ✓

D3302-3

Doubler

**

10 SP

Location

Loc Qty

Loc Code

ST198

2

73095

2

73095

MS21042L3

Purchased No

110 Each

3,091.000

4 4 ✓

MS21042L3

Nut

**

JB SP

Location

Loc Qty

Loc Code

ST300

3091

117441

16

117885

32

118451

5

118927

3

119017

2862

119017

119075

173

MS21919-WDG12

Purchased No

110 Each

34.0000

1 1 ✓

MS21919-WDG12

Clamp

**

JB 12/04/13

Location

Loc Qty

Loc Code

ST307

34

107534

4

110985

30

107534

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-15-12 10:32:16 AM

Page 7

Work Order ID: 81546

Parent Item: D205-706-013

Parent Item Name: Fuel Purge Canister

81546

D205-706-013

Start Date: 15/03/2012

Required Date: 29/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS21919-WDG16

Purchased

No

110

Each

7.0000

2

2

✓

MS21919-WDG16

Clamp

**

JB [Signature]

Location

Loc Qty

Loc Code

ST296

5

119546

5

ST307

2

114523

2

114523

MS21919-WDG9

Purchased

No

110

Each

205.0000

5

5

✓

MS21919-WDG9

Clamp

**

*3x120839

JB [Signature]

Location

Loc Qty

Loc Code

328

200

120986

200

ST307

5

120308

5

2x120308

MS21920-42

Purchased

No

110

Each

18.0000

2

2

✓

MS21920-42

CLAMP(per MIL-DTL-8783C)

**

JB 12/04/13

Location

Loc Qty

Loc Code

ST451

18

119659

8

119673

10

119673

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-15-12 10:32:16 AM

Page 8

Work Order ID: 81546

Parent Item: D205-706-013

Parent Item Name: Fuel Purge Canister

81546

D205-706-013

Start Date: 15/03/2012

Required Date: 29/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS28778-6

Purchased

No

110

Each

27.0000

5

5

✓

MS28778-6

Packing

**

Location

Loc Qty

Loc Code

FP002

10

118354

10

ST294

17

113422

2

117591

15

3x 118354

2x 113422

MS35489-11

Purchased

No

110

Each

20.0000

1

1

✓

MS35489-11

GROMMET

**

Location

Loc Qty

Loc Code

ST295

20

109166

10

119537

10

109166

JB 12/04/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY**5. PARTS LIST**

Qty -011	Qty -013	Qty -015	Part Number	Description
X			D412-706-011	FUEL PURGE CANISTER INSTALLATION (212/412)
	X		D205-706-013	FUEL PURGE CANISTER INSTALLATION (205/214)
		X	D204-706-015	FUEL PURGE CANISTER INSTALLATION (204)
1	1	1	D2001-4	VALVE ASSEMBLY
		2	D2026-101	SCREW
1	1	1	D3262-041	CANISTER ASSEMBLY
2	2	2	D3264-1	BRACKET
1			D3297-1-0098	HOSE ASSEMBLY
	1		D3297-1-0121	HOSE ASSEMBLY
	1		D3297-1-0130	HOSE ASSEMBLY
1			D3297-3-0085	HOSE ASSEMBLY
1			D3297-3-0210	HOSE ASSEMBLY
	1		D3297-3-0350	HOSE ASSEMBLY
		1	D3297-5-0410	HOSE ASSEMBLY
1	1		D3298-001	TUBE ASSEMBLY
1			D3298-003	TUBE ASSEMBLY
1			D3298-005	TUBE ASSEMBLY
1			D3298-007	TUBE ASSEMBLY
1	1		D3298-009	TUBE ASSEMBLY
		1	D3298-011	TUBE ASSEMBLY
		1	D3298-013	TUBE ASSEMBLY
		1	D3298-015	TUBE ASSEMBLY
1	1	1	D3299-1	FITTING
1	1		D3299-3	FITTING
1			D3299-5	FITTING
1	1	1	D3301-1	PLACARD
1	1	1	D3301-3	PLACARD
1	1		D3302-1	DOUBLER
1	1		D3302-3	DOUBLER
		1	D3302-5	DOUBLER
		2	D3302-7	DOUBLER
2			D3329-1	BUSHING
4	4	4	AN3-5A	BOLT
1	1	1	AN814-6D	PLUG
3	2	2	AN815-6D	UNION
		1	AN816-6D	NIPPLE
1			AN832-6D	UNION
2	3	1	AN833-6D	ELBOW
		1	AN919-6D	REDUCER
5	4	1	AN924-6D	NUT
1			AN938-6D	TEE
4	4	2	AN960JD10L	WASHER
8	8	8	AN960JD10	WASHER

• COPYRIGHT © 2004 BY DART AEROSPACE LTD •
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **A**

Date: 04.11.30

S

2	2		AN960JD916	WASHER
4	4	4	MS21042L3	NUT
	1	1	MS21919WDG12	CLAMP
	2		MS21919WDG16	CLAMP
		2	MS21919WDG6	CLAMP
		3	MS21919WDG7	CLAMP
2	5		MS21919WDG9	CLAMP
2	2	2	MS21920-42	CLAMP
10	5	5	MS28778-6	O-RING
1	1	1	MS35489-11	GROMMET

• COPYRIGHT © 2004 BY DART AEROSPACE LTD. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: A

Date: 04.11.30

Work Order ID 81546***81546***

March-15-12 10:32:12 AM

Item ID: D205-706-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fuel Purge Canister

Start Date: 15/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start ***NR1***

Approvals:

Process Plan: MCT

Date: 12/03/15 Tooling:

Date:

Stop ***NR2***

QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D412-706

Rev A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D205-706-013 CHG002

JB

A12 04-13

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control